

Work Order ID 86755

July-06-12 2:17:16 PM

86755

Page 1

Item ID: D2232-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Basket Hinge
 Start Date: 7/06/12 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 8/03/12 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: H Date: 12-07-9 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D2232 | Rev C | | | | | | | | |

100 0.00
100 FLOW WATER JET 6 0 Jun 12-7-13
 Waterjet Memo 0.00
 FLOW CNC Waterjet 1-Cut as per Dwg D2232 Dwg Rev: C Prog Rev: C 2-
304 .125 Deburr if necessary

110 0.00
110 QC2- Inspect parts off machine FAI/FAIB
 QC Memo 0.00
 Quality Control

120 0.00
120 QC8- Inspect parts - second check
 QC Memo 0.00
 Quality Control

(DAS 16 9-83) 12/07/16

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 86755

86755

Page 2

July-06-12 2:17:16 PM

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 Item Name: Basket Hinge
 Start Date: 7/06/12 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 8/03/12 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|------------------------------|
| 130 | Identify as per dwg & Stock Location: _____ | 0.00 | | | | | | | |
| *130* | | | | | | | | | |
| Packaging | Memo | 0.00 | | | | | 6x | | <i>12.07.18</i> |
| Packaging | *****STOCK IN BASKET CELL***** | | | | | | | | |
| 140 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| *140* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | <i>12/7/19</i> |
| Quality Control | | | | | | | | | <i>MF</i> <i>12-07-18</i> |

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

Picklist Print

July-06-12 2:17:15 PM

Page 1

Work Order ID: 86755

Parent Item: D2232-1

Parent Item Name: Basket Hinge

Start Date: 7/06/12

Required Date: 8/03/12

Start Qty: 6.00

Required Qty: 6.00

Comments: IPPB01.06.07Now laser cutEC
IPP Rev:C Now on Waterjet 06-11-21 JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

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|-----------|--|-----------|----|--|--|-----|----|---------|--------|-----------|--|--|--|
| M304S11GA | | Purchased | No | | | 100 | sf | 45.0260 | 0.0243 | 0.1534737 | | | |
|-----------|--|-----------|----|--|--|-----|----|---------|--------|-----------|--|--|--|

304/316 0.125 Sheet

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| MAT020 | 45.026 | |
| 121380 | 23.9 | |
| 121780 | 21.126 | |

121380

Jun 12-713

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

Dart Aerospace Ltd

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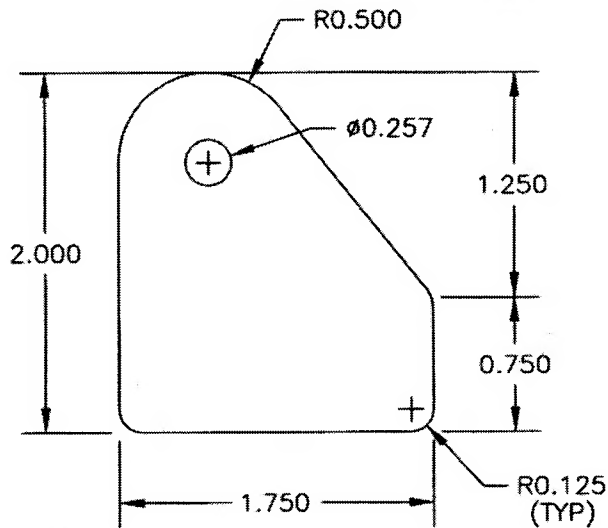
NOTE: Date & initial all entries

DART



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98.05.05 KE

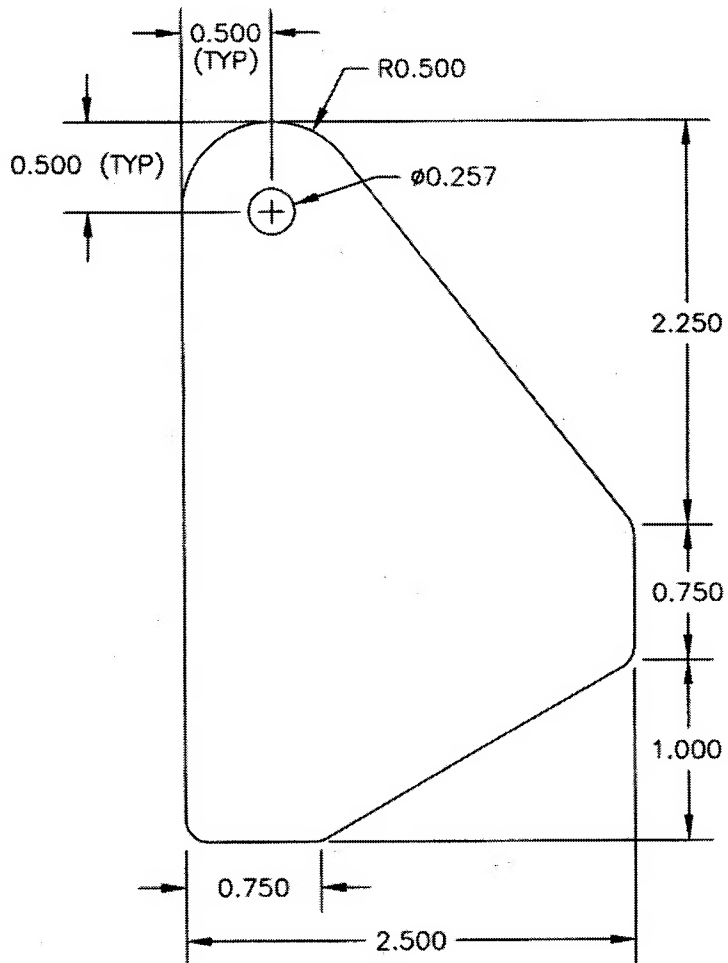
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|-------------------------------|--------------------------------|---|--------------|--|
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. | REV. C | |
| DATE | | D2232 | SHEET 1 OF 2 | |
| 98.04.28 | | TITLE | SCALE | |
| | | BASKET HINGE | 1:1 | |
| A | 94.05.12 | NEW ISSUE | | |
| B | 96.01.02 | ADDED - 5 AND - 7 | | |
| C | 98.04.28 | 0.125 THICK WAS 0.063 | | |



D2232-1

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 16753

012-07-9



D2232-3

MATERIAL: AISI 304/316 SS 0.125 THICK

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

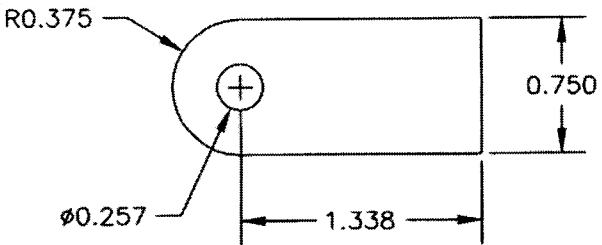
DART



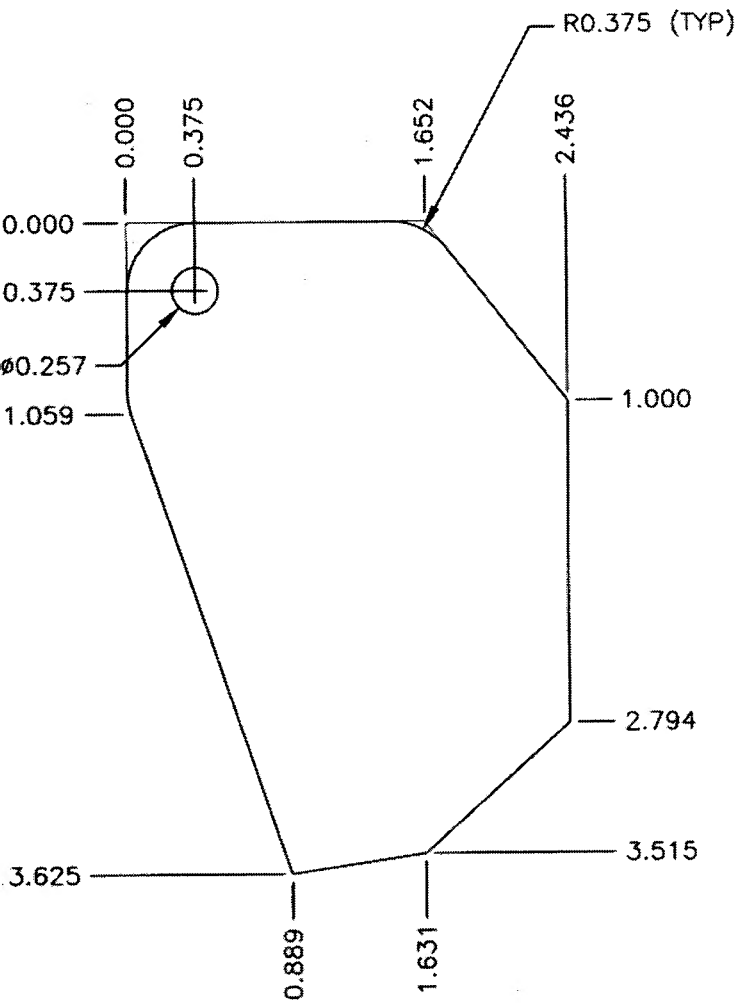
| | | | |
|----------|----------|---|--------------|
| DESIGN | DRAWN BY | DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA | |
| CHECKED | APPROVED | DRAWING NO. | REV. C |
| DATE | | D2232 | SHEET 2 OF 2 |
| 98.04.28 | | TITLE | SCALE |
| | | BASKET HINGE | 1:1 |

RELEASED
98.05.05 KE

76755



D2232-7



D2232-5

MATERIAL: AISI 304/316 SS 0.125 THICK

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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